

Tuesday, May 31, 2016 10:55:13 AM

Page 1

**DAS
13
9-89**

100
50
50

Cust Item ID:

Customer:

Date: MAY 31 2016
Date:

Date:

QC:

Date: MA

SPC (Y/N):

Date:

Stop ***NR2***

**Insp.
Stamp**

Revision Nbr

D3631

Rev A

100

0.00

100

PURCHASING

0.00

Purchasing

Purchasing

Memo

Issue P/O: 32575 Purchase Part Number: 95606A170 Supplier: Mc
Master Carr Certificate of conformity is required

110

Receive & Inspect for Damage & Mat'l Certs

0.00

1 1 0

Packaging

Packaging

Memo

0.17

Ensure certificate of conformity is attached

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Quality Control

Memo

0.00

DAS
38

9-80

MIN 07-2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified ☐	☐	Past Due	☐				

Work Order ID 147068

Tuesday, May 31, 2016 10:55:13 AM

147068

Page 2

Item ID: D3631-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Washer

Stop ***NS2***

Start Date: 6/3/2016 Start Qty: 50.00

50

Cust Item ID:

Required Date: 6/17/2016 Req'd Qty: 50.00

50

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Memo

0.08

Packaging

LOCATION: FP001

JUN 08 2016

DAS
6
9-89

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.83

Quality Control

ML5

JUN 08 2016

ML5

JUN 08 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

Picklist Print

Tuesday, May 31, 2016 10:55:17 AM

Page 1

Work Order ID: 147068

147068

Parent Item: D3631-1

D3631-1

Parent Item Name: Washer

Start Date: 6/3/2016

Required Date: 6/17/2016

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A New Issue 07-07-28 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
95606A170 *95606A170* Washer		Purchased	No			110	Each	0.0000	1	50/100 100x 50/16-6-6.			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

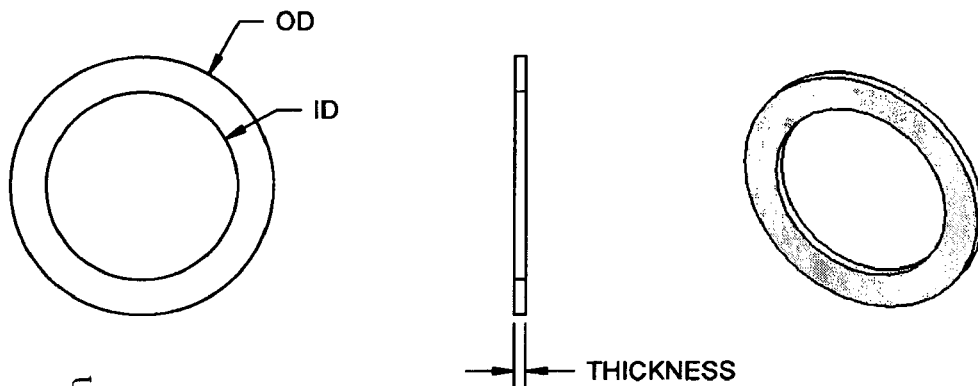
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		FAULT CATEGORY		☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
		☐ OTHER :									



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D3631	REV. A SHEET 1 OF 1
DATE 07.05.16		TITLE WASHER	SCALE NTS
REV A	DATE 07.05.16	DESCRIPTION NEW ISSUE	

SPECIFICATION CONTROL DRAWING



160531
NO. 149068 M.C.S.
WORKING
WITH
SUBJECT TO
UNCONTRACTED
ENGINEERING
REVISIONS
SHOP COPY

D3631-X WASHER

RELEASED
07.08.02 **[Signature]**

PART NUMBER	OD	ID	THICKNESS	MATERIAL	SUPPLIER
D3631-1	0.688	0.500	0.031	NYLON	McMASTER-CARR P/N: 95606A170

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO32575**

Purchase Order Date 6/2/2016

PO Print Date 6/2/2016

Page Number 2 of 6

Order From :
MCMASTER-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

VU-MCM001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 330 995 5500

Ship To Contact
Ship To Phone
Ship Via: Purolator ground ppd
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 10
Currency USD
FOB FCA - (Free Carrier)

Line Total: \$6.66

4	7566K25	TIE WRAP MOUNT	6/6/2016 Yes 6/6/2016	50.00 Each	\$0.16	\$8.12
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AS PER DWG D3600 REV. A
B147088

Line Total: \$8.12

5	95606A170	Washer	6/6/2016 Yes 6/6/2016	50.00 Each	\$0.22	\$10.79
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AS PER DWG D3631 REV. A
B147068

Line Total: \$10.79

6	93695K58	WINDOW SEAL	6/6/2016 Yes 6/6/2016	50.00 f	\$0.31	\$15.40
---	----------	-------------	-----------------------------	------------	--------	---------

AS PER DWG D3802 REV. D
B147067

Note:

6/2/2016



200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada
Attention: Ian
Chantal

Purchase Order
PO32575
Order Placed By
Chantal Lavoie
McMaster-Carr Number
4106070-01

Page 1 of 1
06/02/2016

Line	Product	Ordered	Shipped
1	3408A59 Ball-Nose Spring Plunger with Stainless Steel Ball, Stainless Steel Body, with Element, 5/8"-11 Thread, 7-50 lb Nose Force	4 Each	4
2	1770A525 Cam Lock with Polished Nickel Finish, Keyed to C420A, 3/4" Diameter Hole, 7/64" Material Thickness	20 Each	20
3	91525A120 Type 316 Stainless Steel Flat Washer, Oversized, 1/4" Screw Size, 0.281" ID, 1.000" OD, Packs of 25	1 Pack	1
4	7566K25 Cable Tie Mount, Adhesive/Fastener Mount, 4 Way, 0.21" Tie WD. , White, Packs of 50	1 Pack	1
5	95606A170 Nylon Flat Washer, 7/16" Screw Size, 0.500" ID, 0.688" OD, Off-White, Packs of 100, We Shipped 1 Pack To Meet Your Need For 50 Each	1 Pack	1 <i>SP/6-6-6</i>
6	93695K58 Oil-Rst Fire-Retardant Blended Buna-N Foam, 50 ft. Adhesive-Back Strip, 1/4" Thickness, 1" WD	1 Each	1
7	59915K274 PTFE-Lined Stainless Steel Ball Joint Rod End, 3/8"-24 Right-Hand Male Shank, 3/8" Ball ID, 1-1/4" L Thread	15 Each	15
8	8612K61 ✓ Fabric-Reinforced Silicone Rubber Sheet, HT-Temperature, 24" X 36", 1/16" Thickness	6 Each	6 ✓
9	7014A11 ✓ Easy I. D. Socket Holder, for 1/4" Square Drive, 1/8" - 5/8" Socket Size	1 Each	1 ✓
10	7014A12 ✓ Easy I. D. Socket Holder, for 3/8" Square Drive, 1/4" - 1" Socket Size	1 Each	1 ✓
11	7014A13 ✓ Easy I. D. Socket Holder, for 1/2" Square Drive, 3/8" - 1-1/4" Socket Size	1 Each	1 ✓
12	7014A21 ✓ Easy I. D. Socket Holder, for 1/4" Square Drive, 4MM - 15MM Socket Size	1 Each	1 ✓
13	7014A22 ✓ Easy I. D. Socket Holder, for 3/8" Square Drive, 6MM - 20MM Socket Size	1 Each	1 ✓
14	7014A23 ✓ Easy I. D. Socket Holder, for 1/2" Square Drive, 10MM - 27MM Socket Size	1 Each	1 ✓
15	90177A216 Zinc-Plated Steel Split Ring, 3/4" OD, 5/8" ID, Packs of 50 ✓	1 Pack	1

C216106103

McMaster-Carr Supply Company
200 Aurora Industrial Pkwy
Aurora, OH 44202-8087 USA
Phone: 330-995-5500 Fax: 330-995-9600
E-Mail: cle.sales@mcmaster.com
Employer Identification Number (EIN): 36-1458720

Invoice: 63090584
Purchase Order: PO32575
Release:
McMaster-Carr Number: 4106070-01

ORIGINAL COMMERCIAL
INVOICE.
CERTIFICATE OF ORIGIN

Line	Description	Qty & Unit	Unit Price	Extension
5	95606A170 Nylon Flat Washer, 7/16" Screw Size, 0.500" ID, 0.688" OD, Off-White, Packs of 100, We Shipped 1 Pack To Meet Your Need For 50 Each Country of Origin: United States Schedule B #: 392690 ECCN #: EAR99 NLR	1 PK	\$10.79	\$10.79
6	93695K58 Oil-Rst Fire-Retardant Blended Buna-N Foam, 50 ft. Adhesive-Back Strip, 1/4" Thickness, 1" WD Country of Origin: United States Schedule B #: 400811 ECCN #: EAR99 NLR	1 EA	\$15.40	\$15.40
7	59915K274 PTFE-Lined Stainless Steel Ball Joint Rod End, 3/8"-24 Right-Hand Male Shank, 3/8" Ball ID, 1-1/4" L Thread Country of Origin: United States Schedule B #: 848330 ECCN #: EAR99 NLR	15 EA	\$19.05	\$285.75
8	8612K61 Fabric-Reinforced Silicone Rubber Sheet, HT-Temperature, 24" X 36", 1/16" Thickness Country of Origin: United States Schedule B #: 392099 ECCN #: EAR99 NLR	6 EA	\$71.55	\$429.30
9	7014A11 Easy I. D. Socket Holder, for 1/4" Square Drive, 1/8" - 5/8" Socket Size Country of Origin: United States Schedule B #: 392690 ECCN #: EAR99 NLR	1 EA	\$13.53	\$13.53
10	7014A12 Easy I. D. Socket Holder, for 3/8" Square Drive, 1/4" - 1" Socket Size Country of Origin: United States Schedule B #: 392690 ECCN #: EAR99 NLR	1 EA	\$13.88	\$13.88
11	7014A13 Easy I. D. Socket Holder, for 1/2" Square Drive, 3/8" - 1-1/4" Socket Size Country of Origin: United States Schedule B #: 392690 ECCN #: EAR99 NLR	1 EA	\$14.88	\$14.88
12	7014A21 Easy I. D. Socket Holder, for 1/4" Square Drive, 4MM - 15MM Socket Size Country of Origin: United States Schedule B #: 392690 ECCN #: EAR99 NLR	1 EA	\$13.53	\$13.53
13	7014A22 Easy I. D. Socket Holder, for 3/8" Square Drive, 6MM - 20MM Socket Size Country of Origin: United States Schedule B #: 392690 ECCN #: EAR99 NLR	1 EA	\$13.88	\$13.88
14	7014A23 Easy I. D. Socket Holder, for 1/2" Square Drive, 10MM - 27MM Socket Size Country of Origin: United States Schedule B #: 392690 ECCN #: EAR99 NLR	1 EA	\$14.88	\$14.88
15	90177A216 Zinc-Plated Steel Split Ring, 3/4" OD, 5/8" ID, Packs of 50 Country of Origin: United States Schedule B #: 732620 ECCN #: EAR99 NLR	1 PK	\$11.09	\$11.09
	NOTE Tracking number(s) for this shipment: 633862424901			

Number of Packages: 1